






DART AEROSPACE LTD		Work Order: 22709 B
Description: Dual Disabling Kit (Medium Bell)		Part Number: D412-738-041
		Keyed: <input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3368 Rev. A; D3369 Rev. A1 page 4; D3371 Rev. A page 4; D3393 Rev. A page 1		Qty: 19
		Page 1 of 3

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler		05/03/14	88																				
2	DC	Photocopy bluefile and create labels per PPP D412-738-011 CHG001	N/A																						
3	GA	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2728-7</td><td>Decal</td><td>M15464</td></tr><tr><td>1</td><td>D3373-1</td><td>Cam Lock</td><td>B22575</td></tr><tr><td>1</td><td>D3393-1</td><td>Battery Lock Casing</td><td>B22479C</td></tr><tr><td>1</td><td>D3393-3</td><td>Cam Lock Shaft</td><td>B22556B</td></tr></table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal	M15464	1	D3373-1	Cam Lock	B22575	1	D3393-1	Battery Lock Casing	B22479C	1	D3393-3	Cam Lock Shaft	B22556B	SB	05/03/15	
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal	M15464																						
1	D3373-1	Cam Lock	B22575																						
1	D3393-1	Battery Lock Casing	B22479C																						
1	D3393-3	Cam Lock Shaft	B22556B																						
4	GA	Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.	SB	05/03/14	20																				
5	GA	Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5	SB	05/03/14	20																				
6	GA	Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3369-5</td><td>Washer</td><td>B22709</td></tr><tr><td>2</td><td>5/16WC</td><td>SS Flat Washer</td><td>M15715</td></tr><tr><td>A/R</td><td>N/A</td><td>262 Locktite</td><td>M16517</td></tr></table> Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key Number on page 3	Qty	Part Number	Description	Batch	1	D3369-5	Washer	B22709	2	5/16WC	SS Flat Washer	M15715	A/R	N/A	262 Locktite	M16517	SB	05/03/14	20				
Qty	Part Number	Description	Batch																						
1	D3369-5	Washer	B22709																						
2	5/16WC	SS Flat Washer	M15715																						
A/R	N/A	262 Locktite	M16517																						
7	WS	Tack Weld lock shaft to flat cam Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>SS Rod</td><td>N/A</td></tr></table>	Qty	Part Number	Description	Batch	A/R	N/A	SS Rod	N/A	PD	05-03-15	20												
Qty	Part Number	Description	Batch																						
A/R	N/A	SS Rod	N/A																						
8	GA	Apply crazy glue to caps then press caps into body. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>9567K21</td><td>Polyethelene Cap</td><td>M169164</td></tr><tr><td>A/R</td><td>N/A</td><td>Krazy Glue</td><td></td></tr></table>	Qty	Part Number	Description	Batch	2	9567K21	Polyethelene Cap	M169164	A/R	N/A	Krazy Glue		SB	05/03/15	19								
Qty	Part Number	Description	Batch																						
2	9567K21	Polyethelene Cap	M169164																						
A/R	N/A	Krazy Glue																							
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask Dowel Pins Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3368-1</td><td>Pedal Lock Base</td><td></td></tr><tr><td>1</td><td>D3368-3</td><td>Pedal Lock Cover</td><td></td></tr><tr><td>1</td><td>D3385-1</td><td>Hinge</td><td></td></tr></table> Identify as D3368-051	Qty	Part Number	Description	Batch	1	D3368-1	Pedal Lock Base		1	D3368-3	Pedal Lock Cover		1	D3385-1	Hinge								
Qty	Part Number	Description	Batch																						
1	D3368-1	Pedal Lock Base																							
1	D3368-3	Pedal Lock Cover																							
1	D3385-1	Hinge																							
10	QC3	Inspect Powder Coat																							

RELEASED
15-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-03-16	7	03393-041(x1) lock was tacked inside during welding.		Change lock from keyed alike to keyed unlike. Scrap KA lock take out lock re stock 03393-1	SB 05/03/15	 05-03-16	 Revised	 05-03-16

Part No: D3393-041 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/03/22

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22709
Description: Dual Disabling Kit (Medium Bell)		Part Number:	D412-738-041 D3393-041
Dwg: D3368 Rev. A; D3369 Rev. A1 page 4; D3371 Rev. A page 4; D3393 Rev. A page 1		Keyed:	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
		Qty:	80
		Page 2 of 3	

Step	Location	Procedure	By	Date	Qty																				
11	GA	Press dowel pins into D3368-3 pedal lock cover, then assemble hinge as per Dwg D3368 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td></td> </tr> <tr> <td>1</td> <td>D3373-7</td> <td>Cam Lock</td> <td></td> </tr> <tr> <td>3</td> <td>238-028</td> <td>Ø3/16" Dowel Pin ½" long</td> <td></td> </tr> <tr> <td>4</td> <td>385-039</td> <td>Flat Head Screw</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3373-7	Cam Lock		3	238-028	Ø3/16" Dowel Pin ½" long		4	385-039	Flat Head Screw				
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3373-7	Cam Lock																							
3	238-028	Ø3/16" Dowel Pin ½" long																							
4	385-039	Flat Head Screw																							
12	GA	Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.																							
13	GA	Fabricate D3371-5 Cam Lock as per Dwg D3371 Identify as D3371-5																							
14	GA	Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>262 Locktite</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	262 Locktite																
Qty	Part Number	Description	Batch																						
A/R	N/A	262 Locktite																							
15	GA	Assemble lanyard to cyclic sock as per Dwg D3384 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3384-1</td> <td>Cyclic Sock</td> <td></td> </tr> <tr> <td>2</td> <td>CBL-460</td> <td>Loop Sleeve</td> <td></td> </tr> <tr> <td>28"</td> <td>CBL-1240</td> <td>Cable</td> <td></td> </tr> </tbody> </table> Identify as D3384-047	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock		2	CBL-460	Loop Sleeve		28"	CBL-1240	Cable								
Qty	Part Number	Description	Batch																						
1	D3384-1	Cyclic Sock																							
2	CBL-460	Loop Sleeve																							
28"	CBL-1240	Cable																							
16	GA	Assemble D3384-047 to D3368-051 using ¼"-20 socket head cap screw and washer as per Dwg D3368. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN960-416</td> <td>Washer</td> <td></td> </tr> <tr> <td>1</td> <td>HX-81</td> <td>¼"-20 SHCS 3/8" long</td> <td></td> </tr> </tbody> </table> Identify as D3368-041 & attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	2	AN960-416	Washer		1	HX-81	¼"-20 SHCS 3/8" long												
Qty	Part Number	Description	Batch																						
2	AN960-416	Washer																							
1	HX-81	¼"-20 SHCS 3/8" long																							
17	QC5	Inspect work to Step 16	2	05.03.16	19																				
18	PK	Ensure that keys are attached to D3368-041 and D3393-041 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3368-041</td> <td>Pedal Lock Assembly</td> <td>B22709B</td> </tr> <tr> <td>1</td> <td>D3393-041</td> <td>Battery Lock Assembly</td> <td>B22709B</td> </tr> </tbody> </table> Ensure that keys can be locked and unlocked for each D3368-041 and D3393-041 assembly.	Qty	Part Number	Description	Batch	1	D3368-041	Pedal Lock Assembly	B22709B	1	D3393-041	Battery Lock Assembly	B22709B											
Qty	Part Number	Description	Batch																						
1	D3368-041	Pedal Lock Assembly	B22709B																						
1	D3393-041	Battery Lock Assembly	B22709B																						
19	QC4	Inspect Kit 100% for Completeness on the W/O	N/A	05/03/16	19																				
20	PK	Identify and pack for shipping as per PPP D412-738-011		05/03/16	19																				
21	AC	Cost / part: 4.64		05-02-17	19																				
22	DC	Close W/O 4.86 Inspect Level 21		05.03.18	19																				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/03/16	18	stack : 11 D 3393-041	CL	05/03/16	11	 050316	 050316

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 14, 2005
08:30 am

Work Order No : 0022709
Project Name : D3393-041
Project For : WK511
Work Order Type : Main
Main WO Number :
House Part Number : D3393-041
Description : Battery Lock Assembly
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 03-14-05
Est Finish Date : 03-18-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00